

IN THE CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in the application:

- 1 1. (Currently Amended) A method for forming a dual actuator pivot,
2 comprising:
3 initially forming a flangeless shaft comprising large diameter areas formed at a first
4 and second end of the shaft and a reduced diameter area between the large diameter areas;
5 press fitting a first ball bearing onto [[a]] the shaft to make a shaft subassembly;
6 press fitting a second ball bearing into a top bore of a first sleeve to make a first
7 sleeve subassembly;
8 press fitting a third ball bearing into a bottom bore of a second sleeve and press fitting
9 a fourth ball bearing into a top bore of the second sleeve to make a second sleeve
10 subassembly;
11 stacking on the shaft subassembly the first sleeve subassembly, a spacer, and second
12 sleeve subassembly; and
13 applying an axial load to the first sleeve subassembly, [[a]] the spacer, and the
14 second sleeve subassembly to press fit the first sleeve subassembly, [[a]] the spacer, and the
15 second sleeve subassembly to the shaft assembly to form a complete dual actuator pivot
16 assembly.

- 1 2. (Original) The method of claim 1 further comprising vibrating the
2 complete dual actuator pivot assembly at a low amplitude simultaneously while applying the
3 axial load.

1 3. (Currently Amended) The method of claim 2 further comprising measuring
2 [[the]] a frequency spectrum for the vibrating of the complete dual actuator pivot assembly
3 to obtain a resonance frequency for the first sleeve subassembly and for the second sleeve
4 subassembly.

1 4. (Currently Amended) The method of claim 3 further comprising adjusting the
2 axial load while measuring the frequency spectrum for the vibrating of the complete dual
3 actuator pivot assembly to select a desired resonance frequency for the first sleeve
4 subassembly and for the second sleeve subassembly.

1 5. (Currently Amended) The method of claim 1 further comprising chilling the
2 shaft assembly subassembly before stacking on the shaft subassembly the first sleeve
3 subassembly, [[a]] the spacer, and the second sleeve subassembly onto the shaft
4 subassembly.

1 6. (Currently Amended) The method of claim 1 further comprising heating the
2 first sleeve subassembly, [[a]] the spacer, and the second sleeve subassembly before
3 stacking on the shaft subassembly.

1 7-9. (Canceled)

- 1 10. (Currently Amended) The method of claim [[9]] 1, wherein the large
- 2 diameter areas provide a interference press fit with the fourth ball bearing press fitted into the
- 3 top bore of the second sleeve and with the first ball bearing press fitted at the shaft base and
- 4 provide a snug slip fit at the reduced diameter area for the third ball bearing press fitted into
- 5 the bottom bore of the second sleeve and the second ball bearing press fitted into a top bore
- 6 of the first sleeve.